

Date: Monday, 10/22/2007 3:41:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 35280	
Estimate Number : 12931	
P.O. Number :	Part Number : D29332 UP
This Issue : 10/22/2007 S.O. No. :	Drawing Number : D2933 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34602	Material :
Written By : <u> </u>	Due Date : 11/5/2007 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B34872

SF 08/03/18 (B)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

SF 08/03/18 (C)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

SF 08/03/18 (D)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SF 08/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 35280

Part Number: D29332UP

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/03/24 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M 107005



(8X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08/03/25 (8)
08-03-25

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HD



Comment: INSPECT POWDER COAT

08-03-26 (X8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57429

08/03/27 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



6b powder coat white per 08/03/25 (8X)
m-h

mf 08-03-27

W

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35280
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.128	.128	.128		
B	0.100	0.140		.132	.130	.127	.127		
C	0.100	0.140		.130	.125	.125	.125		
D	0.210	0.230		.229	.217	.219	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.313	.313	.313		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.125	.117	.119	.117		
O	0.540	0.560		.543	.548	.551	.550		
P	0.490	0.510		.505	.496	.505	.505		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.497	2.500	2.500		
S	0.240	0.270		.263	.260	.260	.260		
T	0.100	0.180		.143	.140	.138	.138		
U	1.625	1.635		1.630	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.368	1.368	1.368		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.134	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.574	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SF
Date: 08/02/16

Audited by: SD
Date: 08/03/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35280
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

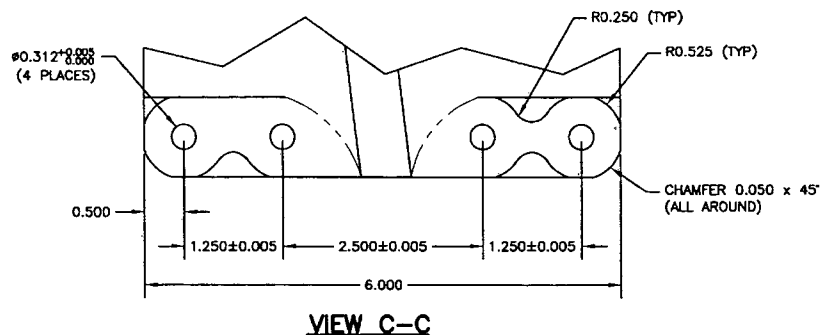
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	54	826	73	84		
A	0.100	0.140		.128	.127	.128	.128		
B	0.100	0.140		.128	.125	.128	.128		
C	0.100	0.140		.125	.123	.123	.123		
D	0.210	0.230		.219	.222	.222	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.119	.117	.119	.117		
O	0.540	0.560		.549	.549	.550	.548		
P	0.490	0.510		.505	.500	.505	.505		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.496	2.500	2.500		
S	0.240	0.270		.261	.261	.262	.261		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.635	1.635	1.635	1.635		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.130	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.570	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DS</u>
Date: <u>08/03/18/19</u>

Audited by: <u>SA</u>
Date: <u>08/03/24</u>

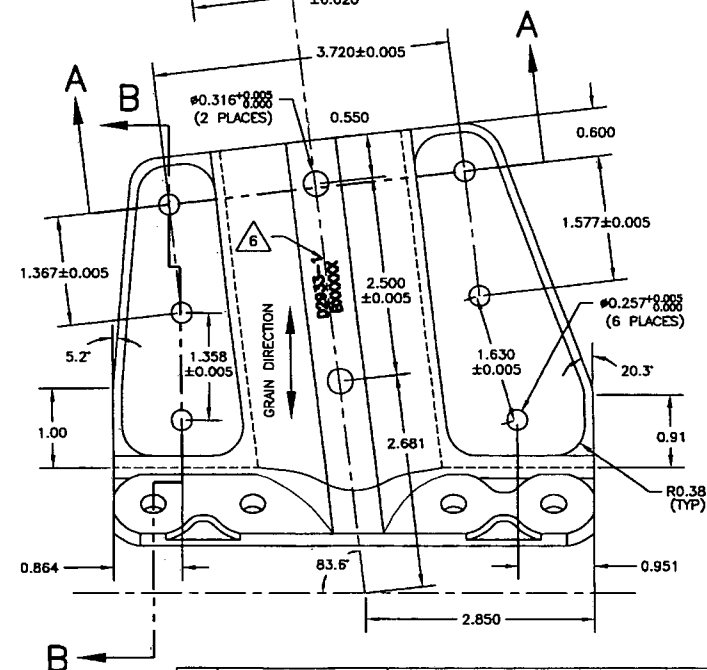
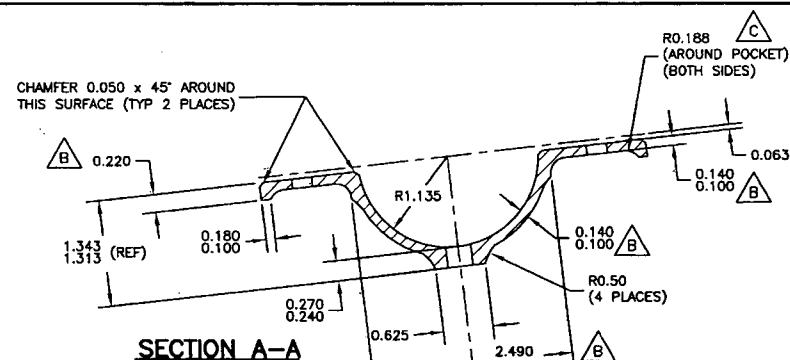
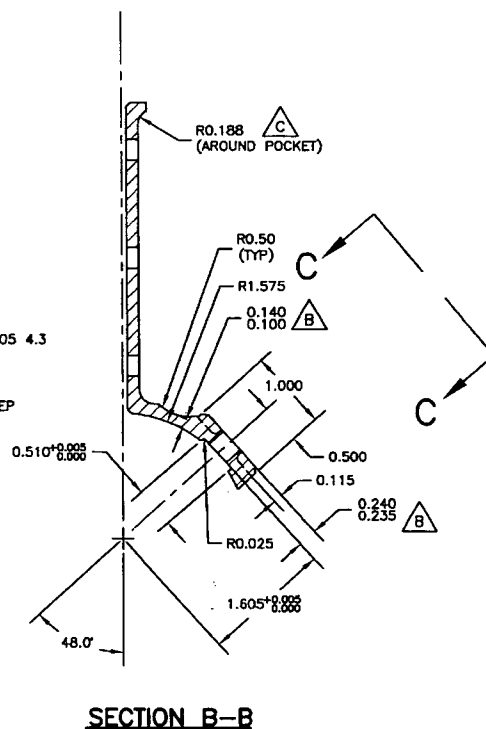
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 35280
 07.02.12



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	TITLE	SADDLE INSIDE
06.11.09	SCALE	2:3

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